

Work Order ID 110389

December-18-13 8:48:54 AM

110389

Page 1

Item ID: D412-630-031

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13 Start Qty: 4.00

4 3x
4

Cust Item ID:

Required Date: 12/31/13 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-18 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| IIN D412-630 | Rev N | | | | | | | | |

100

0.00

110

DC

Document Control

Memo

0.00

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

DAS
31
9-89

14-03-06

3x

110

110

Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble as per IIN D412-630

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

DAS
27
9-89

14/3/4

4x

14/03/04

DAS
36
9-89

120

120

QC

Quality Control

QCS- Inspect part completeness to step on W/O

0.00

Memo

0.00

****ensure tension to retract step is 11 to 18 lbs ****

4

Work Order ID 110389

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Page 2

Item ID: D412-630-031

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/31/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 130 | Pick Kit | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 4 | 3 | | DAS 33 9-89 |
| Packaging | | | | | | | | | 13-12-18 |

140 QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

DAS
31
9-89 14-03-06

3x

150 Packaging 0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-031

Location: 052

PPP Rev: _____

3

DAS
6
9-89

101

MAR 06 2014

1913

1913

Work Order ID 110389

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110389

Page 3

Item ID: D412-630-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 12/31/13 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14-03-7

ME

14-3-21

Picklist Print

December-18-13 8:48:58 AM

Page 1

Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| AN310-4 | | Purchased | No | | | 130 | Each | 82.0000 | 1 | 4 | | | |
| *AN310-4* | | | | | | | | | ** | | | DAS | |
| Nut | | | | | | | | | | | | 33 | |
| | | | | | | | | | | | | 9-89 | |
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228

100

100

228

100

100

Picklist Print

December-18-13 8:48:58 AM

Page 2

Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

AN44-C12

Purchased

No

130

Each

27.0000

1

3

AN44-C12

eyebolt

**

DAS

33

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

3

124829

3

ST361

24

120139

1

123930

1

M126007

10

M126293

12

1+ 120139

2+ 126007

AN4C15

Purchased

No

130

Each

67.0000

1

3

AN4C15

Bolt

**

DAS

33

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST357

17

M126176

17

ST517a

50

M125716

50

126176

AN5C11

Purchased

No

130

Each

24.0000

1

4 3

AN5C11

BOLT

**

DAS

33

9-89

DAS
6
9-89

13-12-20

Location

Loc Qty

Loc Code

ST362

4

120139

4

st503

20

M126007

20

120139

1000

1000

1000

1000

1000

1000

1000

Picklist Print

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Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

AN5C15

Purchased

No

130

Each

34.0000

1 4

AN5C15

BOLT

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST337

14

M126007

14

st503

20

M126012

20

126007

D3454-1

Manufactured

No

130

Each

44.0000

1 4

D3454-1

Bushing

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST045

14

100509

16

108642

28

100509

D3454-3

Manufactured

No

130

Each

45.0000

2 8

D3454-3

Bushing

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST045

45

102973

21

109101

24

102973

D3454-5

Manufactured

No

130

Each

46.0000

2 8

D3454-5

Bushing

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST045

46

102768

22

109102

24

102768

December-18-13 8:48:58 AM

Shop Packet Print

Page 3

Box

Box

Box

Box

Box

Box

Box

Box

Picklist Print

December-18-13 8:48:58 AM

Page 4

Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

D3455-1 Manufactured No 130 Each 63.0000 4 16

3x *D3455-1*

Spacer

**

DAS
33
9-89

DAS
8
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST045

63

102853

27

108643

36

102853

D3455-3 Manufactured No 130 Each 62.0000 2 8

3x *D3455-3*

Spacer

**

DAS
33
9-89

DAS
8
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST045

62

109931

38

95184

24

93784

D3462-041 Manufactured No 130 Each 3.0000 1 4

3x *D3462-041*

Bracket

**

DAS
33
9-89

DAS
8
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST485A

3

102888

3

3+102888

MS21043-3 Purchased No 130 Each 981.0000 3 12

3x *MS21043-3*

Nut

**

DAS
33
9-89

DAS
8
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

GA

13

m126741

13

ST315

888

124555

92

m126741

796

126741

December-18-13 8:48:58 AM

Shop Packet Print

Page 4

100
100
100
100
100

100

100

100

100

100

100

Picklist Print

December-18-13 8:48:58 AM

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Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

MS24665-227 Purchased No

130 Each

20.0000

2 8

3x *MS24665-227*

Cotter Pin

**

M127831

DAS

6
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST299

20

111041

18

120124

2

MS24665-229 Purchased No

130 Each

80.0000

2 8

3x *MS24665-229*

Cotter Pin

**

DAS

33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

GA

80

118234

80

1182341

NAS1149C0363R Purchased No

130 Each

1,094.000

7 28

3x *NAS1149C0363R*

Washer

**

DAS

33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

704

114742

704

ST292

390

122441

390

122441

NAS1149C0563R Purchased No

130 Each

247.0000

1 4

3x *NAS1149C0563R*

Washer

**

DAS

33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST292

247

m125928

247

125928

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Shop Packet Print

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208

208

208

208

208

Picklist Print

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Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5

Purchased

No

130

Each

275.0000

1

4

DAS

33

9-89

NAS1515H5

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

40

103691

40

ST297

235

125574

235

125574

D3463-041

Manufactured

No

110

Each

0.0000

1

4

DAS

33

9-89

D3463-041

Step Weldment Assembly

D3443-043

Manufactured

No

110

Each

1.0000

1

4

D3443-043

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST485

1

101521

1

D3443-041

Manufactured

No

110

Each

1.0000

1

4

D3443-041

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST485

1

101824

1

D3443-9

Manufactured

No

110

Each

72.0000

2

8

D3443-9

Pin

Location

Loc Qty

Loc Code

ST045

72

101480

8

102741

24

109100

40

6 X 101480
2 X 102741

DAS
33
9-89

13-12-20

December-18-13 8:48:59 AM

Shop Packet Print

Page 6

244
Q
1702

Picklist Print

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Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

D3454-7

Manufactured No

110

Each

50.0000

2

8

D3454-7

Bushing

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST045

50

103081

24

109103

24

97306

2

103081

D3455-1

Manufactured No

110

Each

63.0000

2

8

D3455-1

Spacer

**

DAS
33
9-89 13-12-20

Location

Loc Qty

Loc Code

ST045

63

102853

27

108643

36

102853

D3465-1

Manufactured No

110

Each

32.0000

1

4

D3465-1

Washer

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST046

32

102827

26

86713

6

86713

AN4CH3

Purchased No

110

Each

91.0000

2

8

AN4CH3

Bolt

**

DAS
33
9-89 13-12-18

Location

Loc Qty

Loc Code

ST355

91

M126007

41

M126085

50

126007

December-18-13 8:48:59 AM

Shop Packet Print

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Picklist Print

December-18-13 8:48:59 AM

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Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

AN4C14

Purchased

No

110

Each

36.0000

1

4

AN4C14

Bolt

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST356

36

120141

11

m126461

25

120141

AN310-4

Purchased

No

110

Each

82.0000

1

4

AN310-4

Nut

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST342

82

M126400

32

M126872

50

126400

AN310-7

Purchased

No

110

Each

120.0000

1

4

AN310-7

Nut

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST342

120

124198

80

m120124

40

124198

MS24665-227

Purchased

No

110

Each

20.0000

1

4

MS24665-227

Cotter Pin

**

DAS
33
9-89

13-12-18

Location

Loc Qty

Loc Code

ST299

20

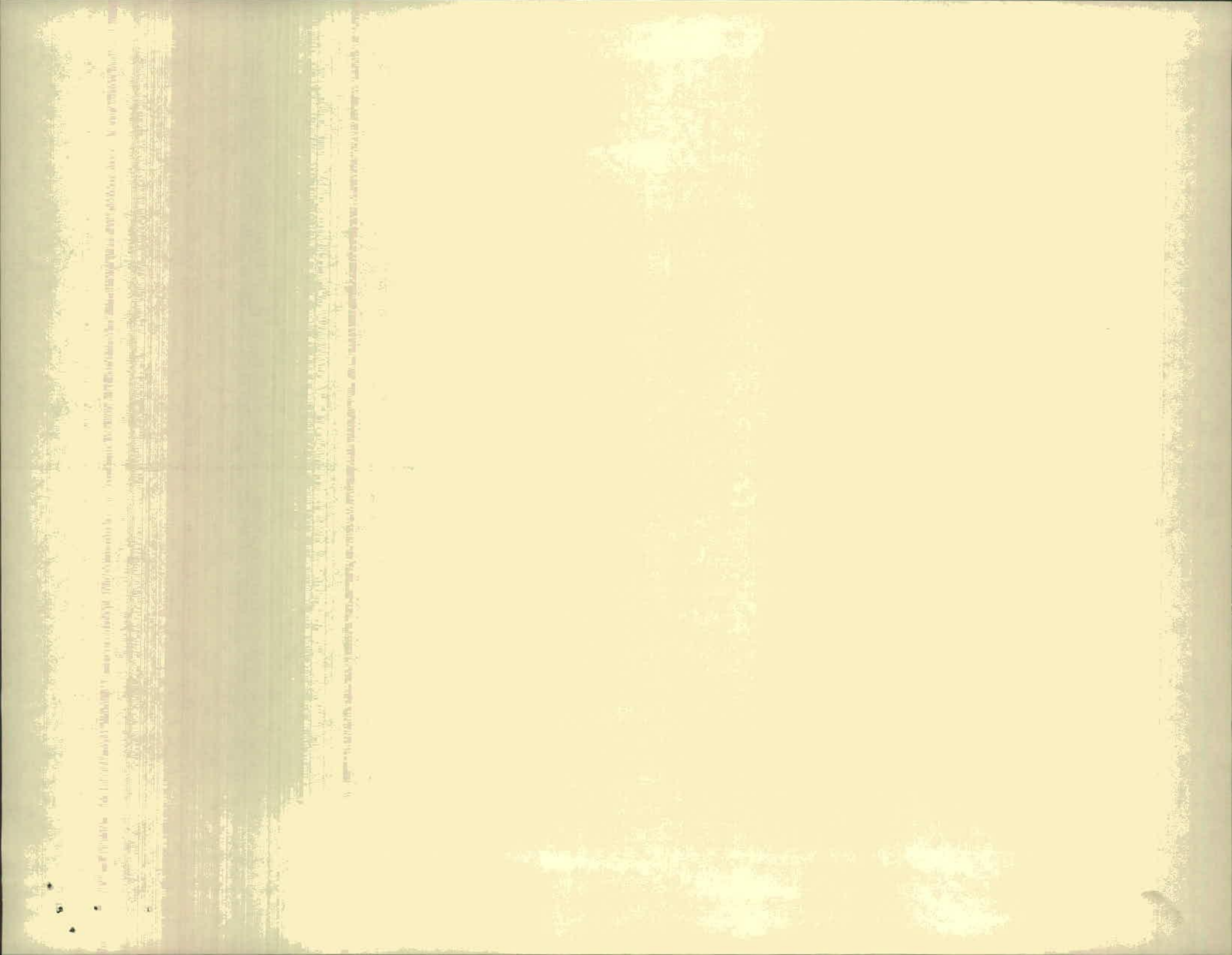
111041

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120124

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12/01/16 J.S.
3x-120124



Picklist Print

December-18-13 8:49:00 AM

Page 9

Work Order ID: 110389

110389

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot / Co-Pilot Folding Step LH

Start Date: 12/17/13

Required Date: 12/31/13

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

194.0000

1

4

MS24665-302

Cotter Pin

**

DAS
33
9-89

13-12-18

Location

Loc Qty

Loc Code

GA

37

120521

37

ST299

157

m127305

157

127305

REFERENCE ONLY

DART AEROSPACE LTD.

DAS
31
0-80

14-03-06

D412-630

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| Qty -031 | Qty -032 | Part Number | Description |
|-------------|-------------|--------------|-----------------------------------|
| X | | D412-630-031 | PILOT/CO-PILOT STEP, LH (FOLDING) |
| | X | D412-630-032 | PILOT/CO-PILOT STEP, RH (FOLDING) |
| 1 | 1 | D3443-041 | STRUT ASSEMBLY |
| 1 | 1 | D3443-043 | STRUT ASSEMBLY |
| 2 | 2 | D3443-9 | PIN |
| 1 | 1 | D3454-1 | BUSHING |
| 2 | 2 | D3454-3 | BUSHING |
| 2 | 2 | D3454-5 | BUSHING |
| 2 | 2 | D3454-7 | BUSHING |
| 6 | 6 | D3455-1 | SPACER |
| 2 | 2 | D3455-3 | SPACER |
| 1 | | D3462-041 | BRACKET ASSEMBLY |
| | 1 | D3462-042 | BRACKET ASSEMBLY |
| 1 | | D3463-041 | STEP ASSEMBLY |
| | 1 | D3463-042 | STEP ASSEMBLY |
| 1 | 1 | D3465-1 | WASHER |
| 2 | 2 | AN310-4 | NUT |
| 2 | 2 | AN310-5 | NUT |
| 1 | 1 | AN310-7 | NUT |
| 3 | 3 | AN3C-5A | BOLT |
| 1 | 1 | AN44-C12 | * EYEBOLT |
| 1 | 1 | AN4C14 | BOLT |
| 1 | 1 | AN4C15 | BOLT |
| 2 | 2 | AN4CH3 | BOLT |
| 1 | 1 | AN5C11 | BOLT |
| 1 | 1 | AN5C15 | BOLT |
| 7 | 7 | AN960C10 | WASHER |
| 1 | 1 | AN960C516 | WASHER |
| 3 | 3 | MS21043-3 | NUT |
| 2 | 2 | MS24665-227 | COTTER PIN |
| 2 | 2 | MS24665-229 | COTTER PIN |
| 1 | 1 | MS24665-302 | COTTER PIN |
| 1 | 1 | NAS1515H5 | WASHER |

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

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Revision: N
Date: 13.09.18

